

Date: Friday, 10/20/2006 11:10:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER	
Job Number : 29090		
Estimate Number : 10892		
P.O. Number : N/A	Part Number : D32861	
This Issue : 10/20/2006 S.O. No. : N/A	Drawing Number : D3286 REV A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A	
Previous Run : 27594	Material : N/A	
Written By : <u>JA OG 10 20</u>	Due Date : 11/15/2006	Qty: <u>36</u> Um: <u>40</u> Each
Checked & Approved By : <u>JA OG 10 20</u>		
Comment : Est A 04/07/14 New issue KJ/JLM		
Est Rev:B Now on Waterjet 06-06-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0786 sf(s)/Unit Total : 3.1458 sf(s)
 304/316 .125 Sheet
 Batch: M101463

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3286
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

SAD 06-10-22

36

SAD 06-10-26

38

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06-10-22

36

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JOG 10-25 (36)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3286

SAB 06/11/06

(36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/20/2006 11:10:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29090

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/06

(36)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57420

11/07/11/07

(36)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/07/11/07

(36)

Job Completion



11 10/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

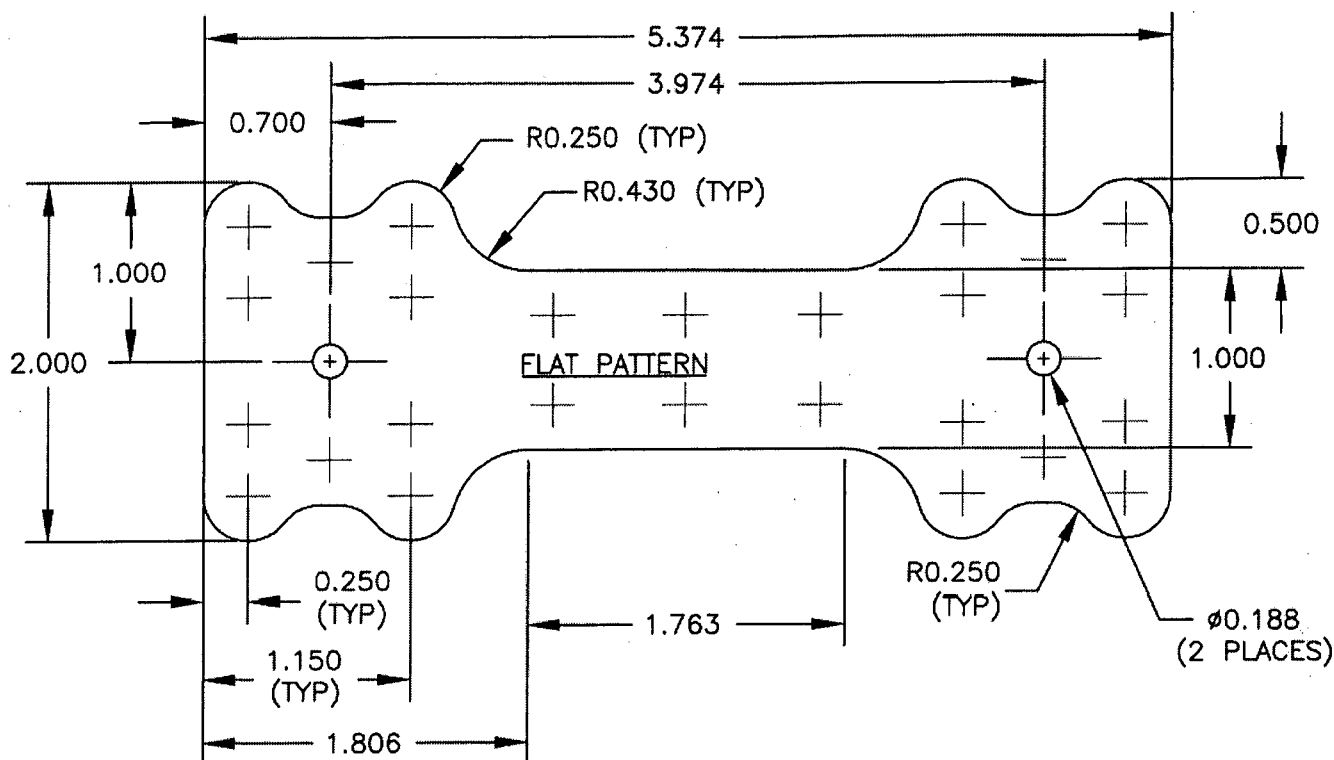
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL

R1.51

RELEASED
04.06.22

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

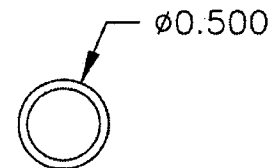
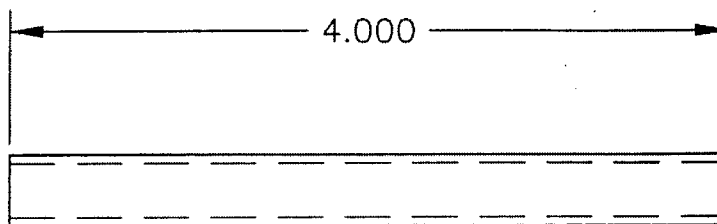
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NO. 29090

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *[Signature]*

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